

5188318



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D6201**Job Sheet 195789****Part No:** D6201**Job Qty:** 11 ft**Part Name:** T Extrusion**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 5/30/19**Job Tracking No:****Due Date:** 6/7/19**Created By:** Chantal Lavoie**Type:** Stock**Description:****Note:** DWG REV A**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing - Ft	11 ft	6/7/19	6/7/19	0.00	0.00	Purchasing - 1		DAS
							Purchasing - 2	✓m	61
							Purchasing - 3		9-89
110	Packaging 2-1 - Receive - B4B	11 pcs	6/7/19	6/7/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		DAS
							Packaging 2 - 28 - B4B	✓m	61
									9-89

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					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120 QC 6	11 pcs	6/7/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61 VM	31
					QC 6 - 40	J-89
130 Packaging 3-1 - Stock - B4B	11 pcs	6/7/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA FT	11 ft	6/7/19	0.00 0.00		QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-89

Part Op 100 - Issue P/O: _____ a)Description: T-beam extrusion b) 4.00" x 4.00" x 0.375" c) Minimum Ultimate Tensile
 Descriptions: Strength = 38ksi d) Minimum Yield Tensile strength = 35ksi e) Material: 6061-T6/T6511 (QQ-A-200/8)
 110 - (Receive & Inspect for Damage & Mat'l Certs) Ensure material certification is attached
 120 - (QC6- All purchased or subcontracted products) Ensure Material certification comply to Dwg D6201
 130 - (Identify as per dwg & Stock Location: _____ LOCATION: MAT028

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6201P	T Extrusion 4X4X3/8	11 ft (1 ea)	100-Purchasing - Ft	5188314

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing - Ft	D6201P	11	0	0

Part Specifications

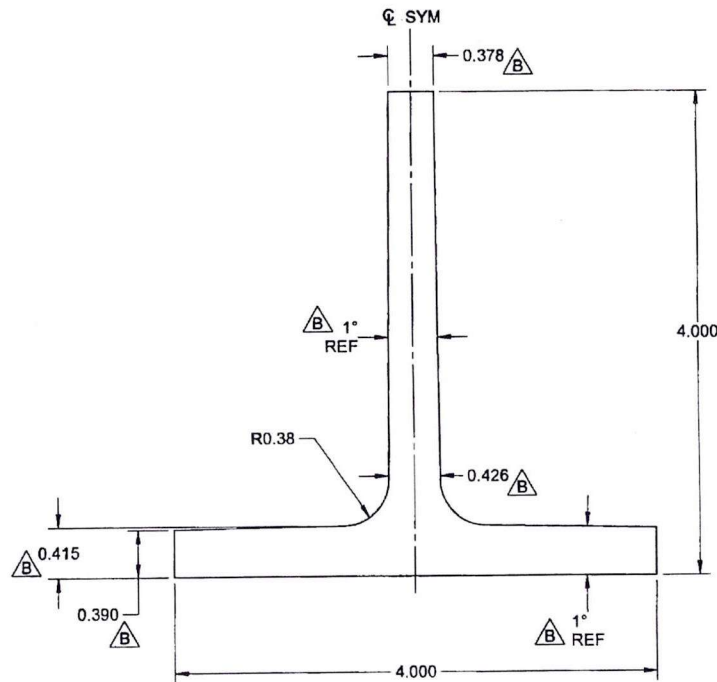
Specifications could not be found.

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SPECIFICATION CONTROL DRAWING

Line 2

D6201



D6201-XXX T-BEAM EXTRUSION
WHERE XXX IS LENGTH IN INCHES
EG. 27 INCHES LONG EXTRUSION: D6201-027

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. ~~195524~~

~~190524~~

195789

NOTES:

- 1) MATERIAL: ALUMINUM T-EXTRUSION, ROUND FILLET
6061-T6/T6511 PER AMS-QQ-A-200/8 OR QQ-A-200/8 OR ASTM B221
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.67 lb/ft

RELEASED
2017-07-27
EN 17-660

B	REFORMAT TO CURRENT STANDARDS: 1" TAPERS DEFINED BY 0.378 & 0.426 AND 0.390 & 0.415 WERE NON-TAPERS (0.375). REASON: CAR17-164. UPDATE MATERIAL CALLOUT.	ML	17.06.05
A	NEW ISSUE	CP	01.04.10
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	LL	D6201	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	CP	T-BEAM EXTRUSION	NTS
DATE	17.06.05	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043557



Supplier: ACI001-VC
Acier Ouellette Inc.
935 Boul. Du Havre
Valleyfield
QC
J6S 5L1 Canada
Phone: 800 667 4248
Fax: 450 377 5696

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043557

PO Date: 5/28/19

Due Date: 6/12/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

REVISED

EMMAILED
MAY 30 2019

Items													
Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price	
1	195526	D6201P		T Extrusion 4X4X3/8 AS PER DWG D6201 REV. A	Firmed	-	6/27/19	20 ft	0 ft	20 ft	\$23.0135/ft	\$460.27	
2	195789	D6201P		T Extrusion 4X4X3/8 AS PER DWG D6201 REV. A	Firmed	-	6/12/19	11 ft	0 ft	11 ft	\$22.00/ft	\$242.00	
Grand Total:												\$702.27	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable). No Raw Metals from China or Soviet Bloc Countries
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program.

A049 supplier awareness.

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

CZ

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**ACIER OUELLETTE INC.**

935, Boul. du H vre
Salaberry de Valleyfield (Qu bec) J6S 5L1
T l.: 450-377-4248 Mtl: 514-336-4248 Ext.: 800-667-4248
Fax: 450-377-5696 Mtl: 514-336-4246 Ext.: 866-456-4242

DELIVERY - CLIENT**Copy**

CO0015022

Billed to	Shipped to	Customer N�	CLI0001056
DART AEROSPACE LTD		Date	2019/05/30
1270 , ABERDEEN ST.	1270 , ABERDEEN ST.	Delivery date	2019/06/06
HAWKESBURY, Ontario, K6A 1K7	HAWKESBURY, Ontario, K6A 1K7	Your order N�	POHB043557
	Att :	Processed by	Josianne Bourdon
		Salesman	JOSIANNE BOURDON
Instruction	Delivery Route	Carrier	OUELLETTE VALLEYFIELD
F-M	5	Credit Terme	Net 30 Days

Product Description	Weight	Qty	UM	PCS NB			Internal Use Only				
				CMD	EXP	B/O	IN	I	S	C	OUT
1 T-BAR ALU 4 X 4 X 3/8 * TBAL-4438 6434 1 X 127" POHB043557 LINE 2 Heat: 852198 AC26566-MGR-03/06 STJ	36.29	10.58	PI_\$CLB		1x 107"						
		1.00	UN_\$UN								
Note : ATTENTION: MILL TEST REQUIS Chaque item identifier avec : - Le # PO client - Le # d'item - Le heat # - Emballer les pi�ces dans carton											

Conditions :

All sold and delivered materials remain the property of "Acier Ouellette Inc" until payment is made in full, complete and cashed. All lost materials are at the buyer's expense. The warranty offered by "Acier Ouellette Inc." is the same as offered and honored by the manufacturer and his warranty is transferred by "Acier Ouellette Inc." to the client. The buyer hereby accepts to respect the following conditions: Net 30 days from billing date and the buyer accepts to pay administration charges of 2% per month (24% per annum) on all past due amounts over 30 days. Any default in respect with this contract will lead to payment by acceleration and permits to the seller, at his choice to claim for the balance due or the repossession of the goods sold. All claims must be made within five (5) days with this document enclosed. Any merchandise that has been damaged, cut or modified cannot be returned. All goods returned must be with our authorization and are subject to a 25% restocking charge.

Total Weight (Lbs) : 36.29

NIR : R-109516-6

Prepared By : 	Verified By :	Delivered By :	Time		Y	M	D
				Customer's Signature	Date		

150227

DART

C129820 26566



SIGNATURE ALUMINUM CANADA
1850 CLEMENTS RD
PICKERING, ON L1W 3R8

CERTIFICATE OF COMPLIANCE

05/31/2015	5357009	118419	1
PO37565	020743	852198 <i>coulee</i>	05/31/15
Vm			
002	C-031522-10	240" MILL 6061 T6511	3/8X4X4" TEE ALUMINUM
774 LBS			
752 LBS		11 PCS	1 PKGS
ASTM B221-08			

Mechanical Tests:

<u>Tensile</u>	<u>Yield</u>	<u>% Elongation</u>	<u>Conductivity</u>	<u>HRE</u>
<u>MPA / KSI</u>	<u>MPA / KSI</u>			
334.5 / 48.5	304.2 / 44.1	15.4	N/A	92

Chemical Analysis:

<u>Si</u>	<u>Fe</u>	<u>Cu</u>	<u>Mn</u>	<u>Mg</u>	<u>Cr</u>	<u>Zn</u>	<u>Ti</u>	<u>V</u>	<u>Zr</u>
0.60	0.24	0.19	0.06	0.87	0.06	0.06	0.02	0.01	0.00

This Material is Made in Canada

This Material is RoHS Compliant

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta
Director of Quality
Signature Aluminum Canada Inc

ISO 9001/T316949 Registered Company

Visit us at www.signaturealuminum.com

Heat: 852198

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6201
 DATE: JUNE 6 2019

PO / BATCH NO.: POHBO43557/
S188318

MATERIAL CERT REC'D: Yes
 QUANTITY RECEIVED: 11ft
 QUANTITY INSPECTED: 11ft
 QUANTITY REJECTED: —

THICKNESS ORDERED: 3/8"
 THICKNESS RECEIVED: 3/8"
 SHEET SIZE ORDERED: —
 SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	☒ Y N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	☒ Y N	
CORRECT MATERIAL PER M-DRAWING	☒ Y N	<u>A57m B221</u>
CORRECT THICKNESS	☒ Y N	
PHOTO REQUIRED	Y ☒ N	
CORRECT REF # TO LINK CERT	☒ Y N	<u>252198</u>
CORRECT MATERIAL IDENTIFICATION	☒ Y N	
CORRECT M# ON THE MATERIAL	☒ Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>Um</u> 61 9.89	SIGNED OFF BY: _____	
DATE: <u>JUN 06 2019</u>	DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in